

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017822**Date Inspected:** 25-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China

CWI Name:	Xu Xian Ping	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG	

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

Heat straightening of PCMK, E20TR2-038 under approved Heat Straightening procedure, HSR1 (B)-362. The in process temperature at the time of this observation was witnessed as 500°C. The ZPMC QC was identified Xiang Feng Feng. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

This QA Inspector during a random observation in Bay 1 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Xiang Feng Feng who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: E2-SB1-001

Welder: 215397

WPS-B-T-2132-3

PCMK: E2-SB1-008

Welder: 215397

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WPS-B-T-2132-3

Bay 2

This QA Inspector during a random observation in Bay 2 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Zhu Jun who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: E2-SB1-026-053,054

Welder: 201583

WPS-B-T-2132-3

PCMK: E2-SB1-027-026~131

Welder: 204730

WPS-B-T-2132-3

PCMK: E2-SB1-055-026~131

Welder: 207465

WPS-B-T-2132-3

PCMK: E2-SB1C-006-032~043

Welder: 062708

WPS-B-T-2132-3

This QA Inspector observed the following work in progress for Bay 2. Submerged Arc Welding (SAW) welding of weld joint 001 located on PCMK SA8501-001. Welder was identified as 045265. ZPMC QC is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S-2.

Bay 3

This QA Inspector observed the following work in progress for Bay 3. Submerged Arc Welding (SAW) welding of weld joint 001 located on PCMK LD3041-001. Welder was identified as 044780. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2C-S-2.

PCMK: LD3041-001-001

Welder: 207288

WPS-B-T-2221-B-L2C-S-2

This QA Inspector during a random observation in Bay 3 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Zhu Jun who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: LD3042-001-001

Welder: 217805

WPS-B-T-2231-B-U2-F-1

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Bay 4

This QA Inspector during a random observation in Bay 4 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Zhu Jun who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: BP-3079-001- 079,080

Welder: 208235

WPS-B-T-2232-3

PCMK: BP-3079-001- 079,080

Welder: 206623

WPS-B-T-2232-3

This QA Inspector during a random observation in Bay 4 observed Flux Cored Arc Welding (FCAW) repair welding of weld joint located on BP-3083A and BP-3084A with repair report No B-CWR1818 rejected by ZPMC UT, Welder is identified as 055491 ZPMC QC is identified as Zhu Jun

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-1G (1F)-repair-1.

Bay 6

This QA Inspector during a random observation in Bay 6 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Xu Hai Yang who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: WJF-0-065

Welder: 215083

WPS-B-T-3311-TC-P4

PCMK: WJF-0-053

Welder: 049769

WPS-B-T-3311-TC-P4

Bay 7

This QA Inspector during a random observation in Bay 7 observed Flux Cored Arc Welding (FCAW) welding in progress. ZPMC QC is identified as Zhu Tian Shu who was documenting the welding in process, which appeared to comply with the approved WPS. Listed below are the locations that were identified by this QA inspector.

PCMK: W2-SB4-001-020~025

Welder: 048625

WPS-B-T-2132-3

PCMK: SP3151-001-023,024,011,012

Welder: 062447

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WPS-B-T-2132-3

PCMK: W2-SB1-031-063~074

Welder: 205386

WPS-B-T-2133

PCMK: W2-SB1-028-094,095

Welder: 053742

WPS-B-T-2332-TC-P4-F

PCMK: SA3077-009-001

Welder: 051246

WPS-B-T-2331-P2-F-2

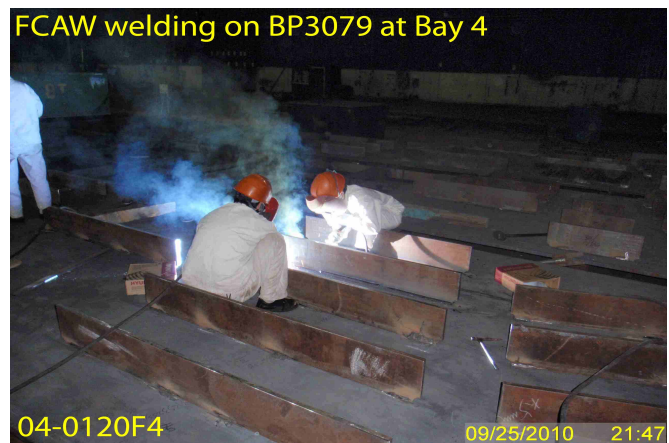
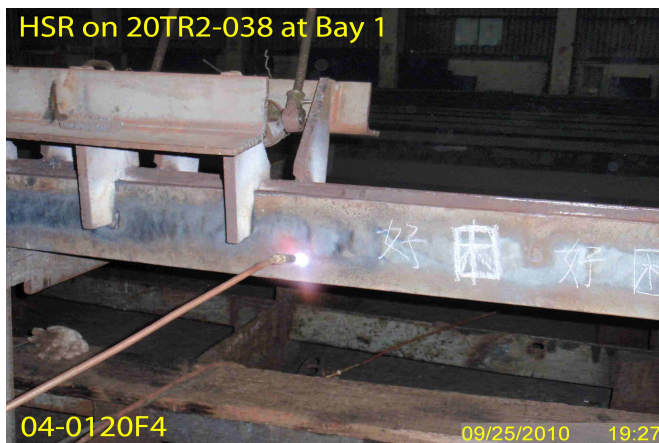
PCMK: SA3077-010-001

Welder: 051246

WPS-B-T-2331-P2-F-2

Heat straightening of PCMK, W2-SB1-028,018,027 under approved Heat Straightening procedure, HSR (B)-9327. The in process temperature was at the time of this observation was witnessed as 400°C~500°C. The ZPMC QC was identified as Shen Jian Guo. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
